

Date: Wednesday, 3/21/2007 3:41:05 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END CAP
Job Number	: 31409		
Estimate Number	: 11675		
P.O. Number	: N/A	Part Number	: D28502
This Issue	: 3/21/2007 S.O. No. : N/A	Drawing Number	: D2850 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 29849	Material	: N/A
Written By	: <u>                    </u>	Due Date	: 4/20/2007
Checked & Approved By	: <u>                    </u>	Qty:	20 Um: Each
Comment	: Est. B 98.12.07 Changed folio DM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2500X01500	6061-T6 Bar 2.5" x 1.5"
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Comment: Qty.: 0.3368 f(s)/Unit Total : 6.7368 f(s)

\* 6061-T6 Bar 2.5" x 1.5"

6061-T6 2.5" X 1.5"

Batch M10974

07/03/23

20

2.0	SHEAR	SHEAR
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Comment: SHEAR

Shear blanks: 3.8"

07/03/23

20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2850-2

Deburr and Tumble

07/03/26

20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/03/26

20

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/03/27

20

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/03/29 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
010326	3.0	-2 parts scrapped while adjusting program. Program wasn't making part to right size		- Prog. will have to be changed  Replace	SA 01/03/26 QSI012 07/03/27	 07/03/26		 07/03/26

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 31409

Part Number: D28502

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(24)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/30

Job Completion



07-0330

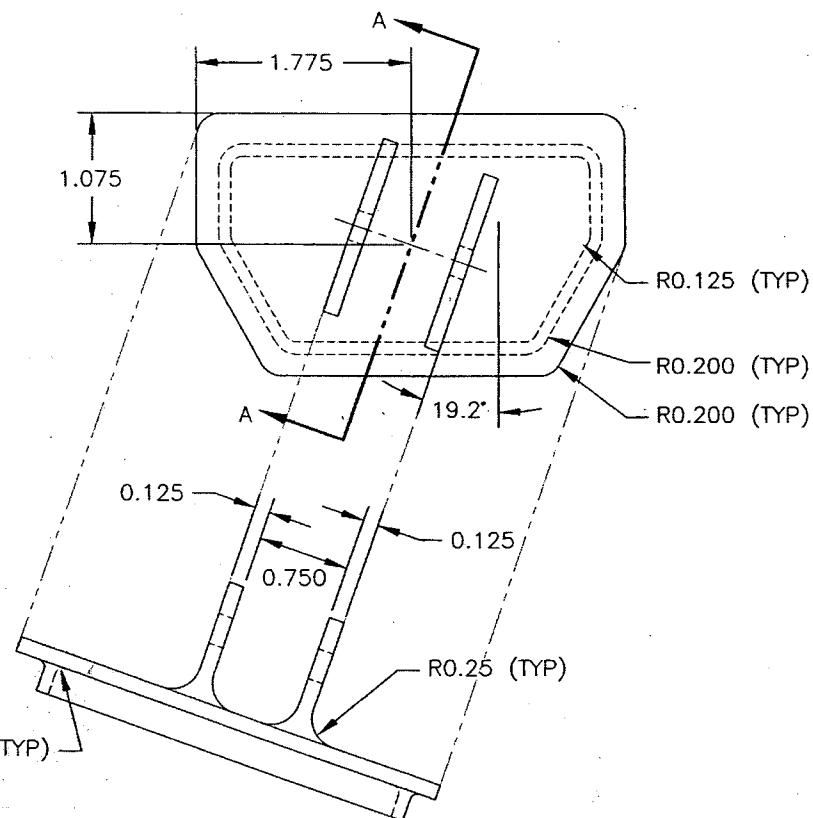
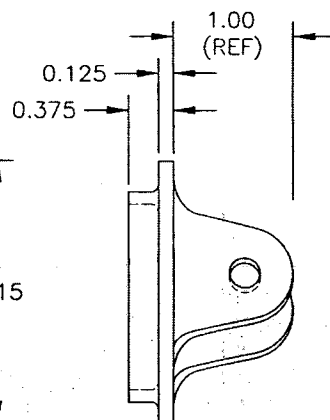
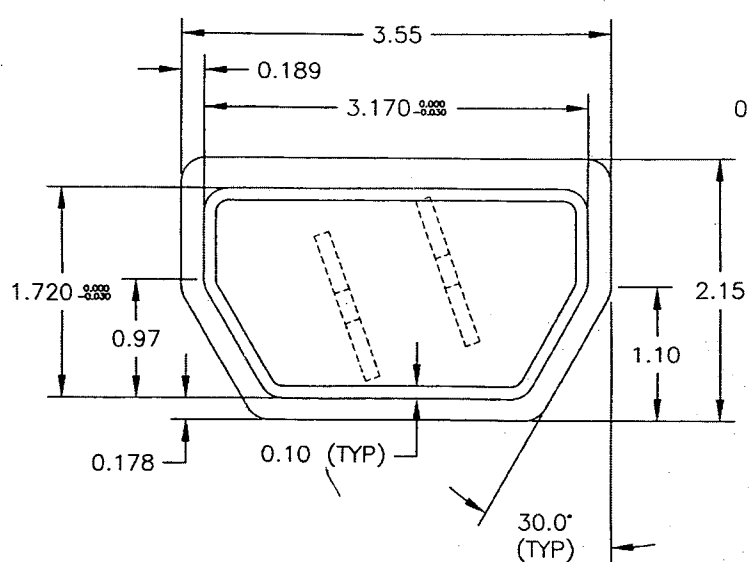
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2850-1 (SHOWN)  
D2850-2 (OPPOSITE)

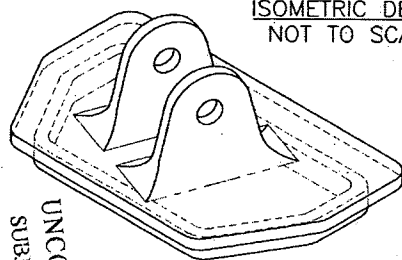
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

FINISH: NONE

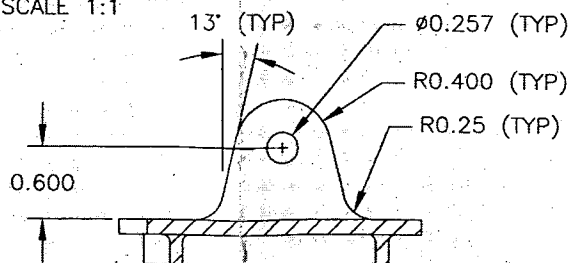
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

ISOMETRIC DETAIL  
NOT TO SCALE



SECTION A-A  
SCALE 1:1



RELEASED  
95.11.25  
COPY 1000

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN	OP	DART	DART AEROSPACE LTD WARRICKSBURY, OXFORD, CANADA
CHECKED	KE	DRAWING NO.	D2850
DATE	98.11.10	TITLE	HIGH FLOAT STEP END BRACKET
		REV. A	SHEET 1 OF 1
		SCALE	1:1

Copyright 1998 by DART AEROSPACE LTD

NO. 31409  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
ENGINEERING  
RETURN TO  
SHOP COPY

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31409
<b>Description:</b> END CAR		<b>Part Number:</b> 02850-2
<b>Inspection Dwg:</b> 02850 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.55	±.030	3.552	/			
B .189	±.010	.189	/			
C 1.720	±.000 ±.030	1.718	/			
D .178	±.010	.179	/			
E .10	±.030	.098	/			
F 30°	±.5°	30°	/			
G 2.15	±.030	2.152	/			
H						
I .375	±.010	.373	/			
J .125	±.010	.120	/			
K 1.00 (Ref)	±.030	1.013	/			
L						
M .125	±.010	.135	/			
N .750	±.010	.748	/			
O R.25		R.25	/			
P R.063		R.063	/			
Q						
R Ø.257	±.006 ±.001	Ø.258	/			
S .600	±.010	.606	/			
T						
U						
V						
W						
X						
Y						

<b>Measured by:</b> SA	<b>Audited by:</b> Er	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07-03-26	<b>Date:</b> 07/03/26	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
		New Issue	KJ/RF	